

Work Order ID 101481 - 2

May-13-13 1:02:46 PM

101481

Page 1

Item ID: D3065-3

Revision ID:

Item Name: Step Spacer

Start Date: 5/13/13

Required Date: 5/24/13

Reference:

Start Qty: 100.00

Req'd Qty: 100.00

100

100

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

MCS

Date: 13-05-06

Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept
Qty Reject
Qty Reject
Number Insp.
Stamp

Draw Nbr

Revision Nbr

D3065

Rev B

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D Dwg Rev: B Prog Rev: B 2-Deburr
if necessary

2024-040

105

0

Jun 13-10-26

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

105

0

Jun 13-10-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B 10 28

105

0



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Page 2

Item ID: D3065-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Step Spacer
 Start Date: 5/13/13 Start Qty: 100.00 *100* Cust Item ID:
 Required Date: 5/24/13 Req'd Qty: 100.00 *100* Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo Debur Stack	0.00 0.00		N/A	WAS 30 1-10				
140 *140* Brake NC Brake NC	NC BRAKE Memo Bend as per Dwg D3065	0.00 0.00			WAS 30 1-10				
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							

136/30

105
can

BK30

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Page 3

Item ID: D3065-3

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Spacer

Start Date: 5/13/13 Start Qty: 100.00

100

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

Chemical Conversion Coat per QSI005 4.1

0.00

160

Hand Finish

Memo

0.00

Hand Finishing

86 7/13/11/4

170

QC Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

85x

13/11/11
DAS
36
9-89

180

Identify as per dwg & Stock Location

0.00

180

Packaging

Memo

0.00

Packaging

85x

13/11/11
DAS
36
9-89

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Page 4

Item ID: D3065-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Spacer

Start Date: 5/13/13 Start Qty: 100.00

100

Cust Item ID:

Required Date: 5/24/13 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00

190

QC

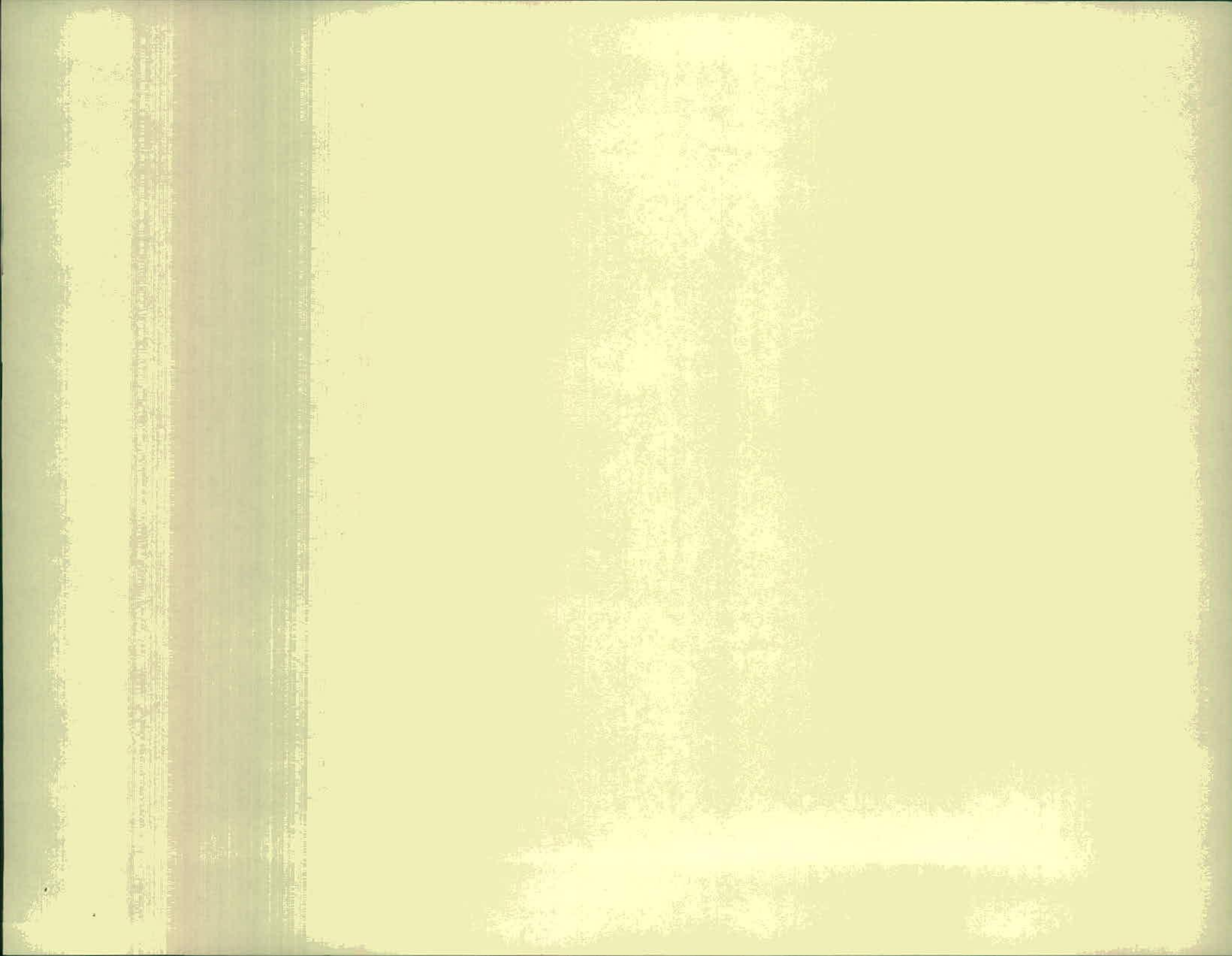
Memo

0.00

Quality Control

[Signature] / 13-11-11

ME
13-11-11



Picklist Print

May-13-13 1:02:45 PM

Page 1

Work Order ID: 101481
 Parent Item: D3065-3
 Parent Item Name: Step Spacer

Start Date: 5/13/13
 Start Qty: 100.00

Required Date: 5/24/13
 Required Qty: 100.00

Comments: IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF
 IPP Rev:D Now on Water Jet 06-04-11 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	437.0877	0.2178	22.92632 23			

Jm3-10-26

Location	Loc Qty	Loc Code
MAT022	437.0876922	
120605	65.8254832	
121197	57.187894	
122136	31.78	
123217	20.894315	
124987	261.4	

24983

DART AEROSPACE LTD		Work Order:	101481
Description: Step Spacer		Part Number:	D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.260	+/-0.010	1.264	-			low
3.260	+/-0.010	3.264	-			
5.260	+/-0.010	5.266	-			
5.520	+/-0.010	5.523	-			
2.093	+/-0.010	2.091	-			
3.936	+/-0.010	3.938	-			
4.186	+/-0.010	4.190	-			
Ø0.129	+0.005/-0.000	0.129	-			
Ø1.250	+0.005/-0.000	1.251	-			
Pitch 1.204	+/-0.005	1.200	-			
0.040	+/-0.010	0.040	-			

Measured by: Jm	Audited by: Jm	Preliminary Approval:
Date: 3/10/26	Date: 13/10/28	Date:

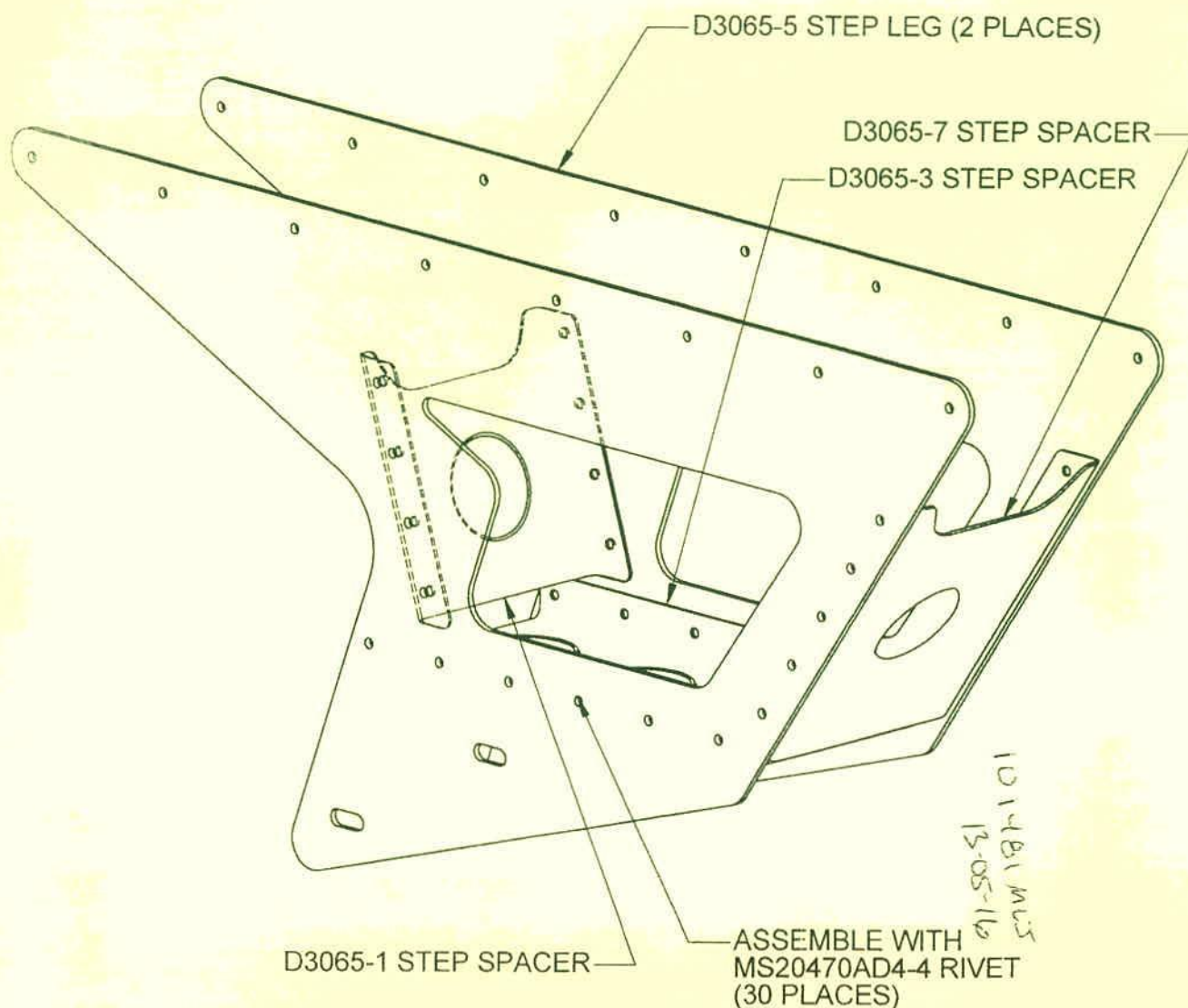
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	
E	12.10.10	Ø0.129 was Ø0.128	KJ	



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SHEET 1 OF 5 SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 *[Signature]*



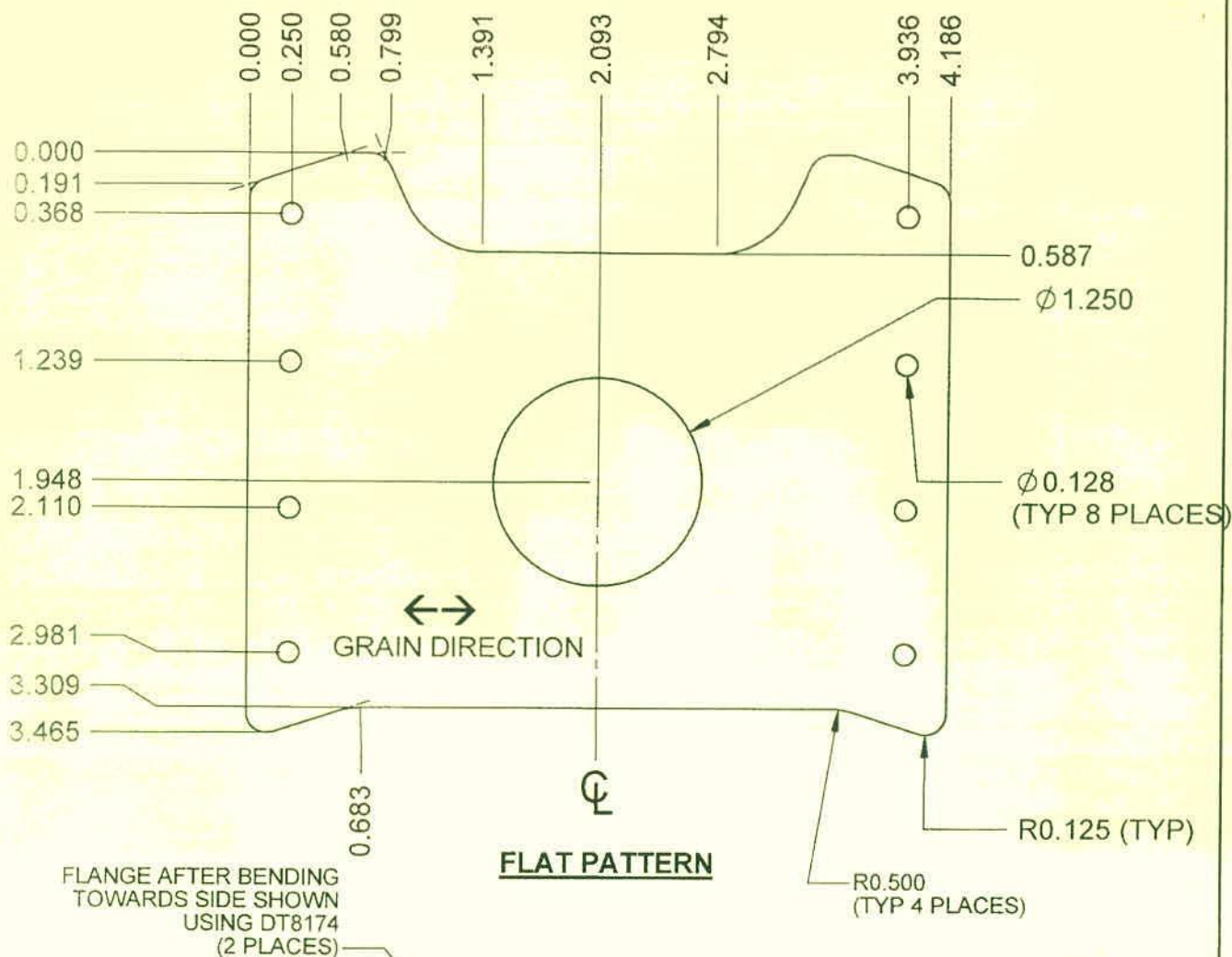
D3065-041 STEP LEG ASSEMBLY

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1



D3065-1 STEP SPACER

BEND DETAIL

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

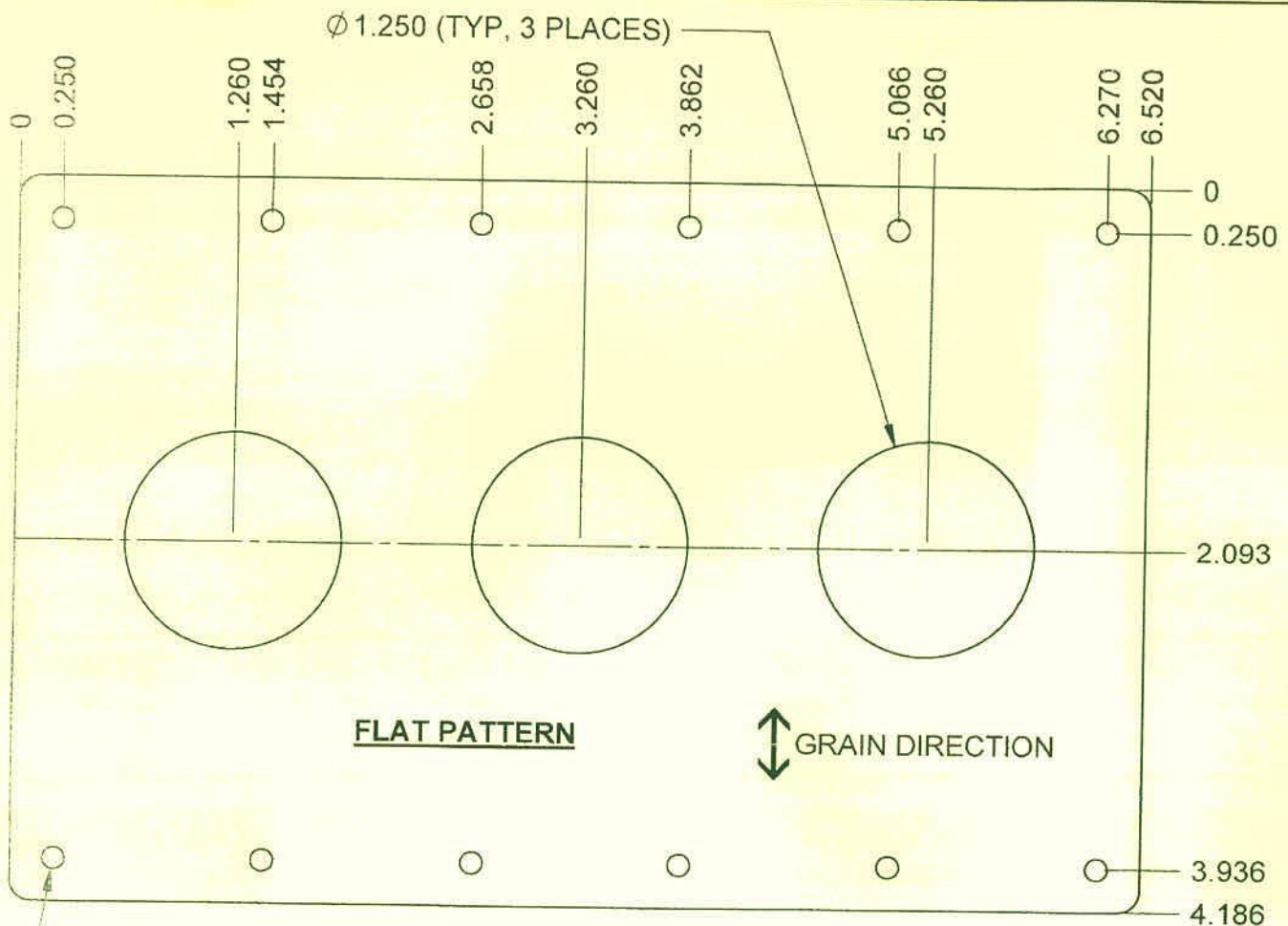
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10/4/01

DART

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DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:1

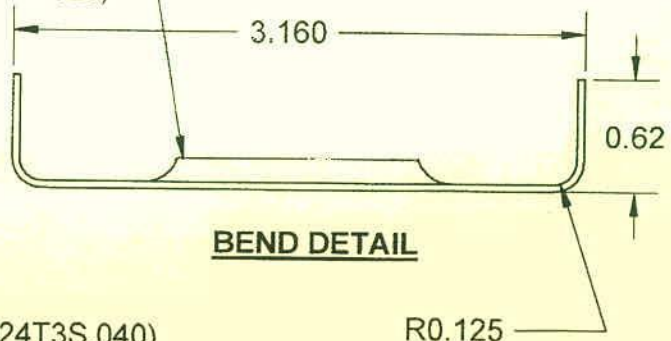


FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

RELEASED

06.06.20 *[Signature]*



BEND DETAIL

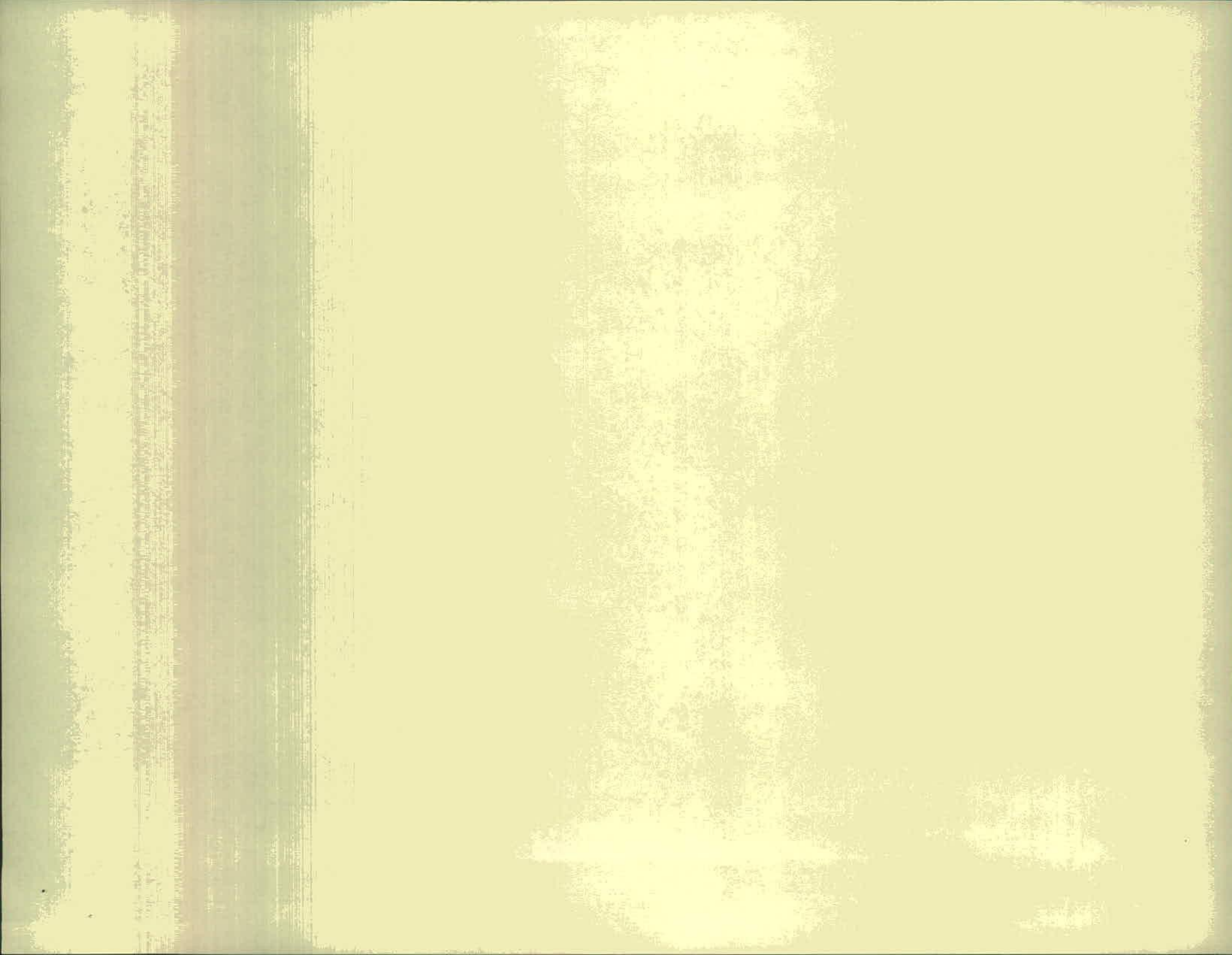
D3065-3 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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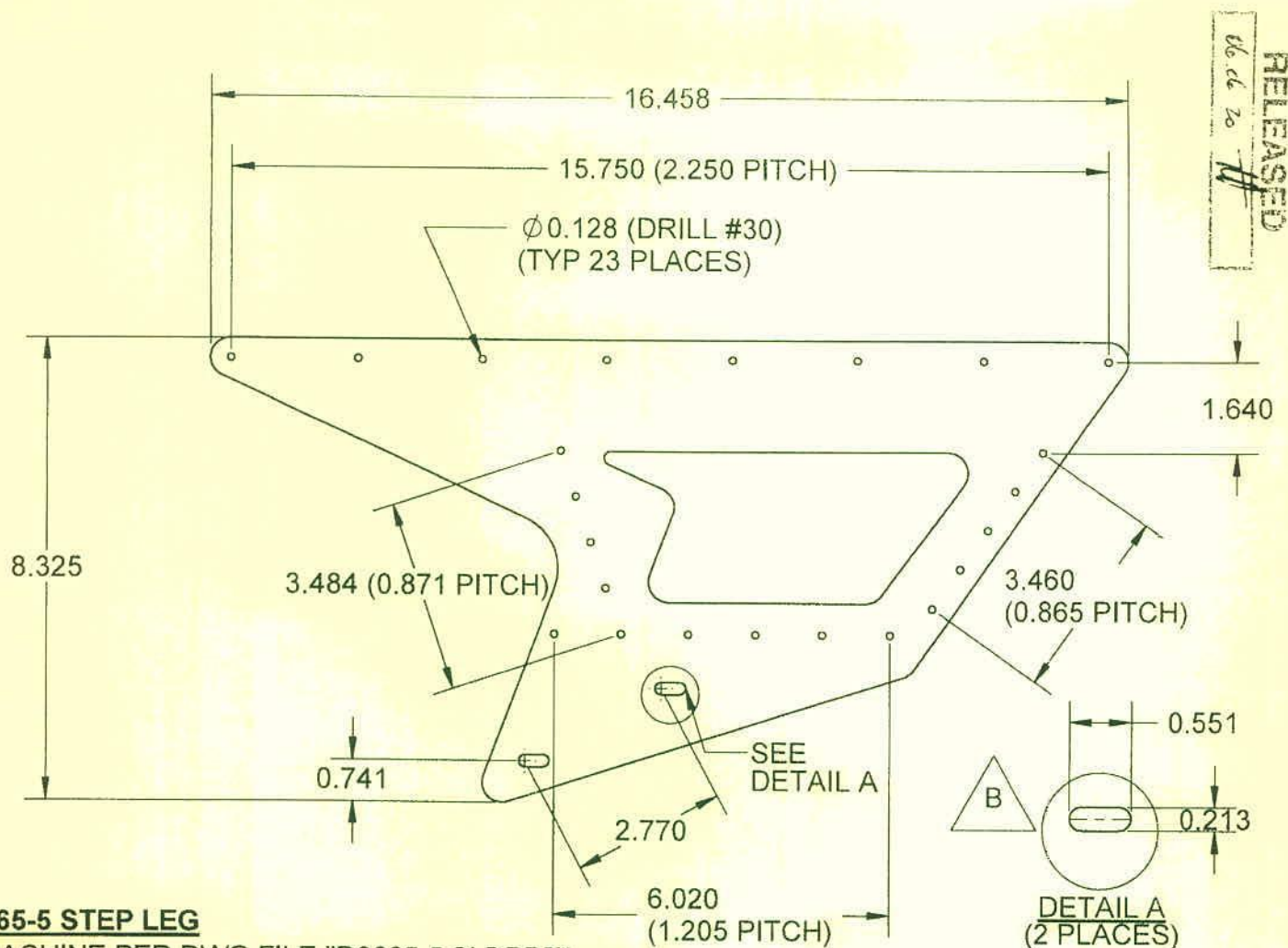
13/10/1





101481

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CHECKED	PH	APPROVED	PH	HAWKESBURY, ONTARIO, CANADA
DATE	06.05.23	DRAWING NO.	D3065	REV. B
TITLE	STEP LEG ASSEMBLY	SHEET 4 OF 5	SCALE	1:3

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

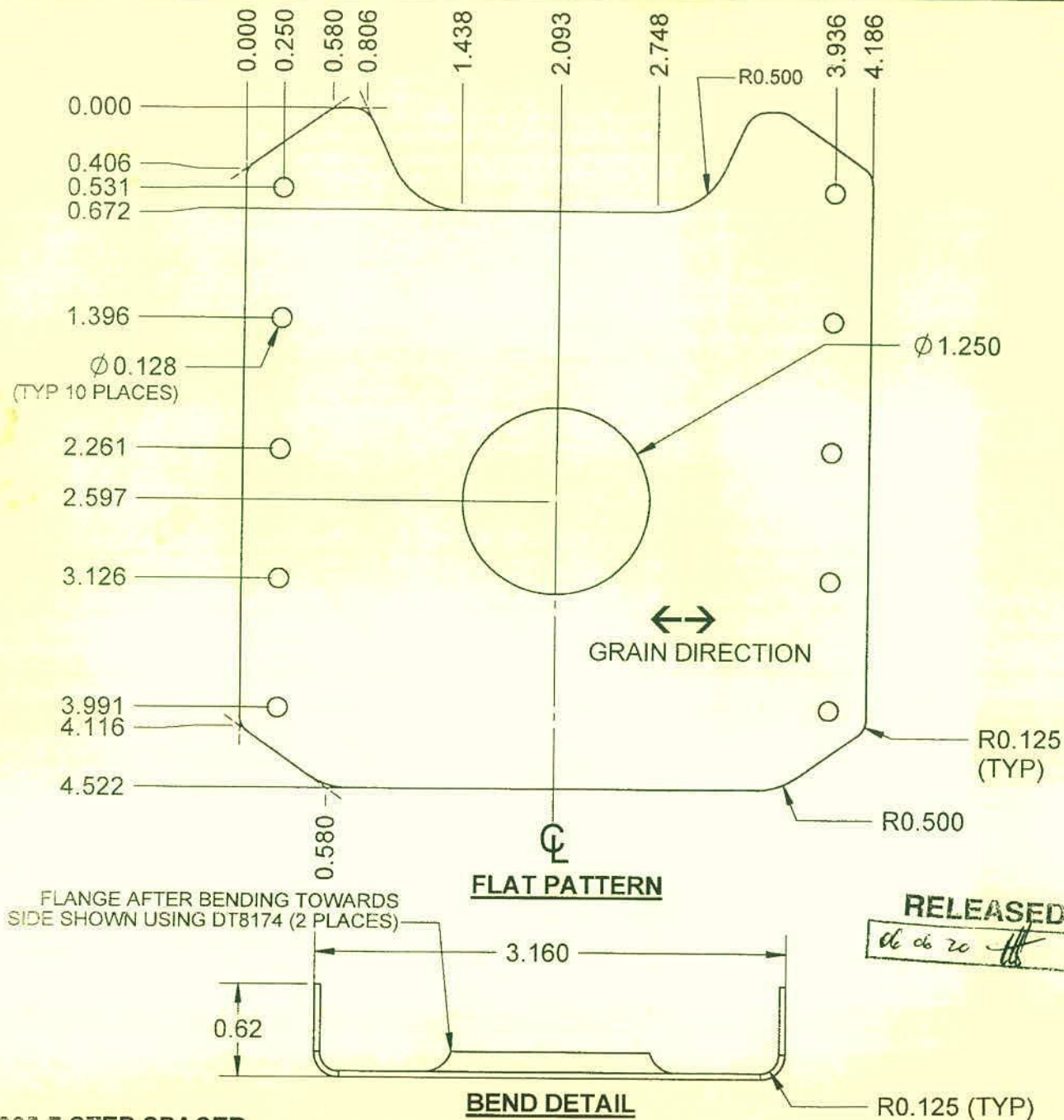
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1



D3065-7 STEP SPACER

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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